

ASAP

Dart Aerospace Ltd.

Date: Monday, 2/25/2008 7:33:37 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP BRACKET
 Job Number : 37579
 Estimate Number : 13160
 P.O. Number :
 This Issue : 2/25/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D37281
 First Issue : 1/1 Type : SMALL /MED FAB Drawing Number : D3728 U/R
 Previous Run : 37492 Drawing Revision : U/R
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A 08-01-30 new issue DD verified by:EC



Qty: 12 Um: Each

Additional Product

Job Number:



Seq. # Machine Or Operation: Description:

1.0 M6061T6B0250X06000 6061-T6 Bar .25" x 6.0"



Comment: Qty.: 1.3484 f(s)/Unit Total: 16.1809 f(s)
 6061T6 aluminium bar 6.00" X .250" thick
 (M6061T6B0250X06000)
 Batch: 107130 IB 8-2-26

Each

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3728

Dwg Rev: B

Prog Rev: B

2- Deburr if necessary

U/R IB 8-2-26

IB 8-2-26

(12)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

0602.27 (12)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

*OTA holes to new Dwg. ch. 0.257"

1- Deburr if necessary

2- grind water jet marks all around bracket smooth

do not grind inside where step extrusion goes

MR 08-03-10
 B0803/04 (12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		open					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AD Date: 08/03/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/03/17</u>	<u>2</u>	<u>open hole size 0.191" are</u> <u>to be opened to 0.257".</u> <u>AS per DWG.</u> ~ <u>45</u>						

NOTE: Date & initial all entries

Date: Monday, 2/25/2008 7:33:37 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP BRACKET

Job Number: 37579

Part Number: D37281

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP

AS 08.03.10



**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

08/03/10 (12)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08-03-11

(12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(12X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 08/03/11

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: GA

MF 08-03-11

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

08/03/11

Job Completion



U 08.03.11

POSITIVE RECALL

EFFECTIVE 08.02.11 AUTH

RELEASED AS DATE 08.03.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE
AJS 08.02.25

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM
PER AMS-QQ-A-250/11 OR AMS 402
(REF DART SPEC M6061T6S.250)
OR: 6061-T6 (OR 6061-T651/T6510/T651)
PER AMS-QQ-A-225/8 (OR AMS 411)
PER AMS-QQ-A-200/8 (OR AMS 416)
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER D
- 3) TOLERANCES: PER DART QSI 018 UNLESS OT
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.93 lbs

A8, 2.520 DIM WAS 2.51 & TOLERANCE
ATED. ZONE A7 & B8 Ø0.159 HOLES

AJS 08.02.22

AJS 08.02.04

DESCRIPTION

BY DATE

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

REV. B

D3728

SHEET 1 OF 2

TITLE

SCALE

STEP BRACKET

NTS

COPYRIGHT © 2008 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8

7

2

1

D

D

R0.125
4 PL

3.15

2.75

R5.0



R0.29

R2.09

R0.59

5.35
REF

C

C

0.68

0.25

B

B

1.250

0.625

0.625

1.40

0.87

0.440

4.25

2.520
+0.010
-0.000

120°

0.440

0.576

Ø0.155
4 PL**PRELIMINARY ISSUE**

AJS 08.02.25

A

A

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADADRAWING NO.
D3728REV. B
SHEET 2 OF 2TITLE
STEP BRACKETSCALE
1:2COPYRIGHT © 2008 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8

7

2

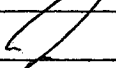
1

DART AEROSPACE LTD		Work Order: 37579
Description: STEP BRACKET		Part Number: D3728-1
Inspection Dwg: D3728-1 Rev: U/R		Page 1 of 1

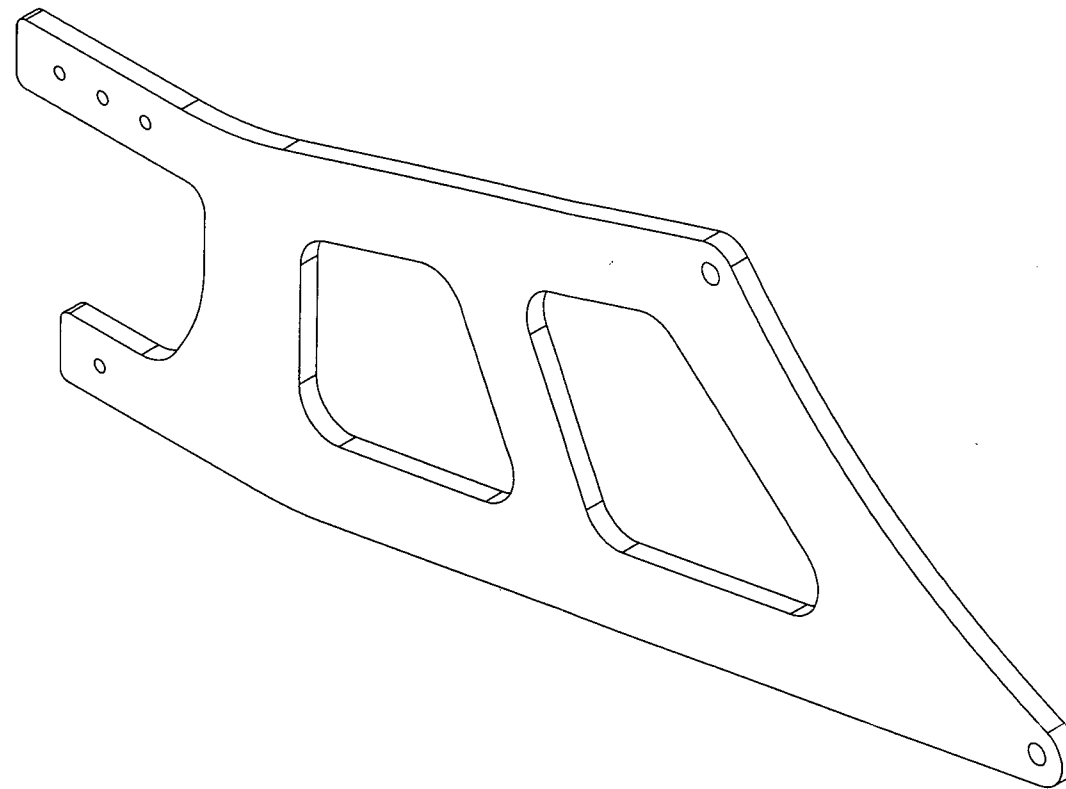
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .191	+ .005 - .001	.194	*			
Ø .159	+ .005 - .001	.160	✓			
.440	+/- .010	.442	*			
.87	+/- .030	.885	*			
.625	+/- .010	.625	*			
.625	+/- .010	.625	*			
1.250	+/- .010	1.253	*			
1.40	+/- .030	1.416	X			
2.520	+/- .010	2.511	*			
4.25	+/- .030	4.276	X			many Dims / to 1
.576	+/- .010	.576	*			
1.00	+/- .030	1.019	*			
1.00	+/- .030	1.025	*			
1.00	+/- .030	1.013	*			
2.370	+/- .010	2.370	*			
6.051	+/- .010	6.051	*			
15.41	+/- .030	15.41	✓			
2.75	+/- .030	2.756	*			
.68	+/- .030	.68	*			
10.212	+/- .010	10.212	✓			
6.070	+/- .010	6.070	*			

Measured by: IB	Audited by: 	Prototype Approval:
Date: 8-2-26	Date: 0802-27	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

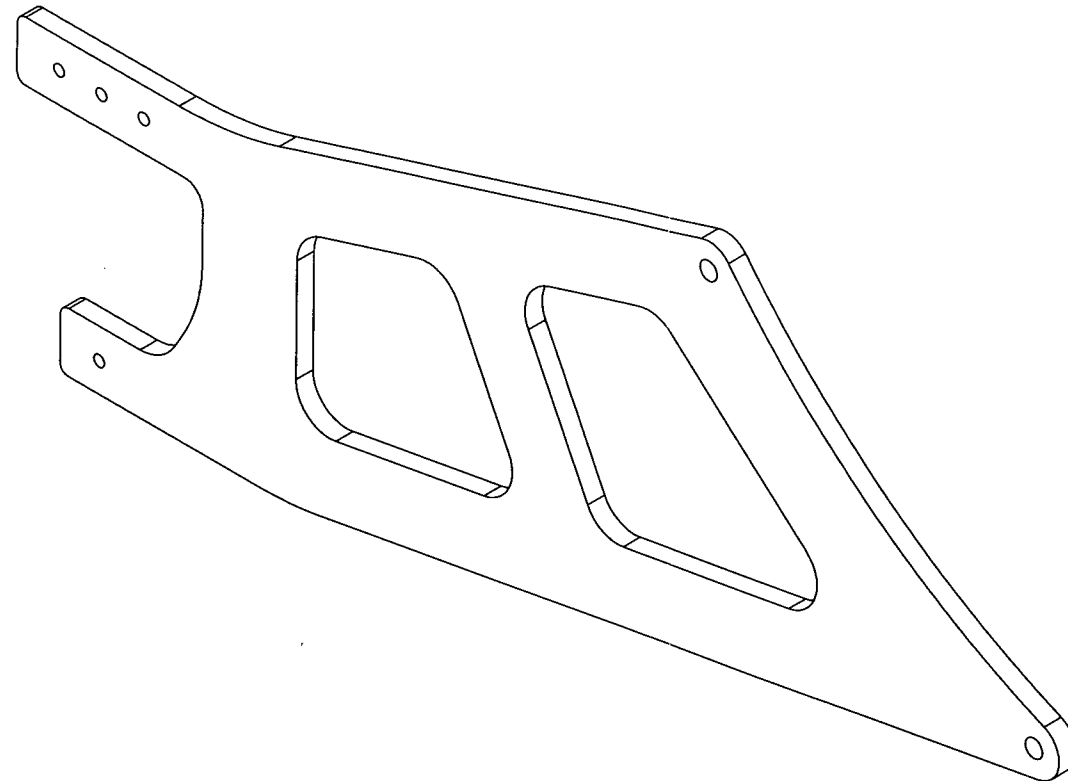


D3728-1 STEP BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.250 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.250)
OR: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.93 lbs

B	SHEET 2 ZONE A4. Ø0.257 HOLE WAS Ø0.191, A8, 2.520 DIM WAS 2.51 & TOLERANCE HAS BEEN UPDATED. ZONE A7 & B8 Ø0.159 HOLES ADDED.	AJS	08.02.22
A	NEW ISSUE	AJS	08.02.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	ME	DRAWING NO.	REV. B
MFG. APPR.	ME	D3728	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STEP BRACKET	NTS
DATE	08.02.22	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3728-1 STEP BRACKET

PRELIMINARY ISSUE
AJS 08.03.10

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.250 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.250)
OR: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.93 lbs

B	SHEET 2 ZONE A4, Ø0.257 HOLE WAS Ø0.191, A8, 2.520 DIM WAS 2.51 & TOLERANCE HAS BEEN UPDATED. ZONE A7 & B8 Ø0.159 HOLES ADDED.		AJS	08.02.22
A	NEW ISSUE		AJS	08.02.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.		REV. B
MFG. APPR.		D3728		SHEET 1 OF 2
APPROVED		TITLE		SCALE
DE APPR.		STEP BRACKET		NTS
DATE	08.02.22		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

D

C

B

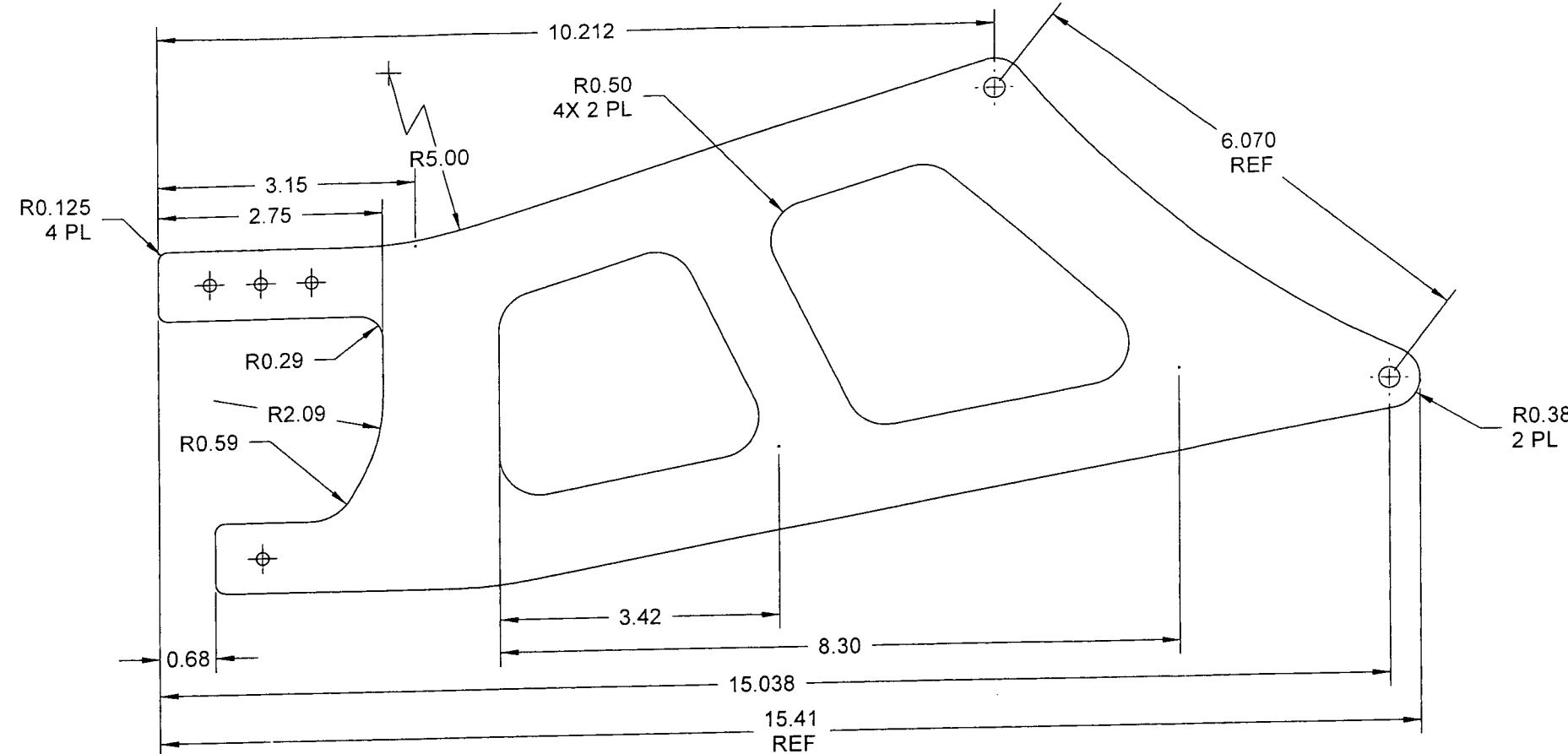
A

D

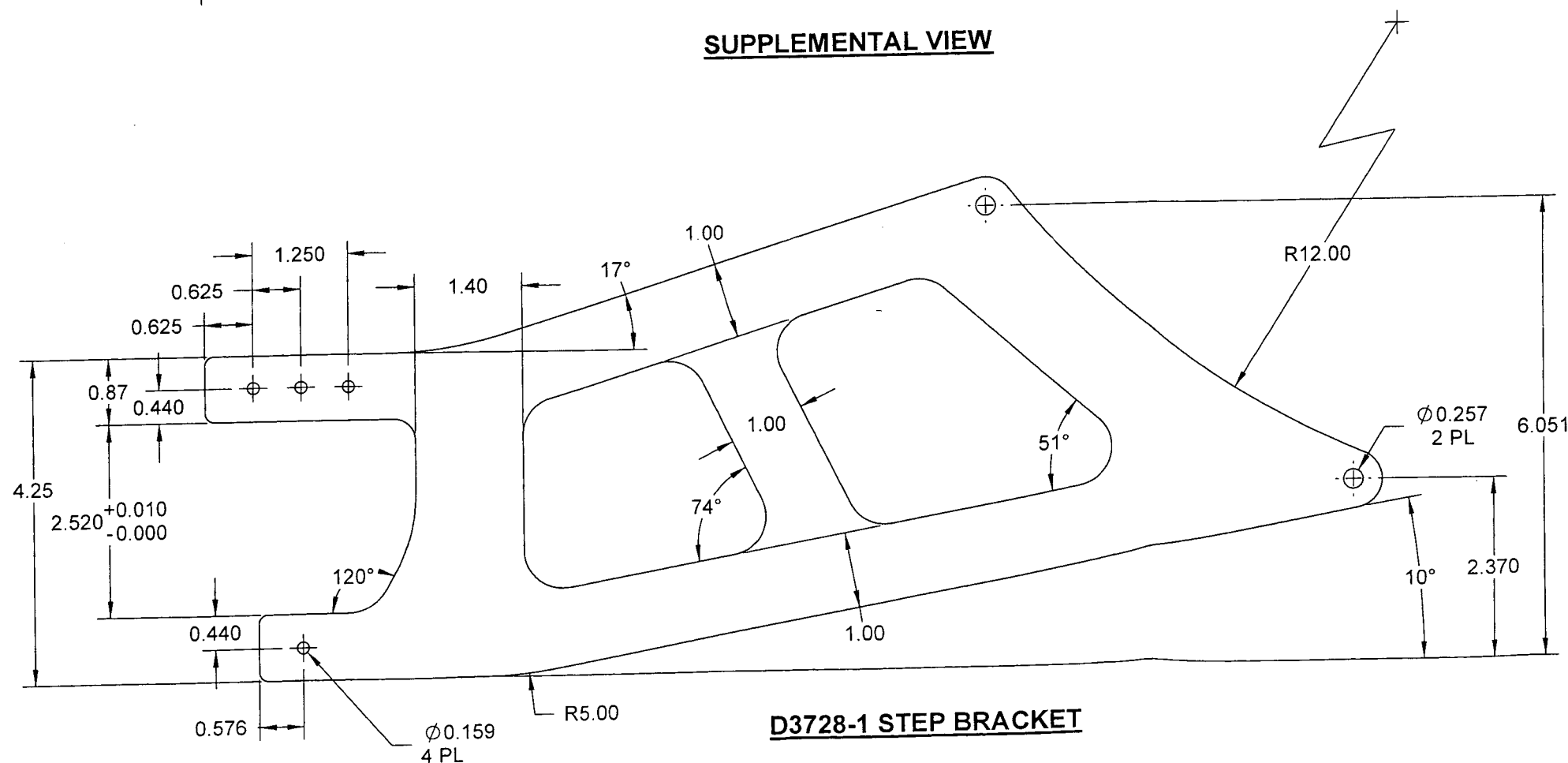
C

B

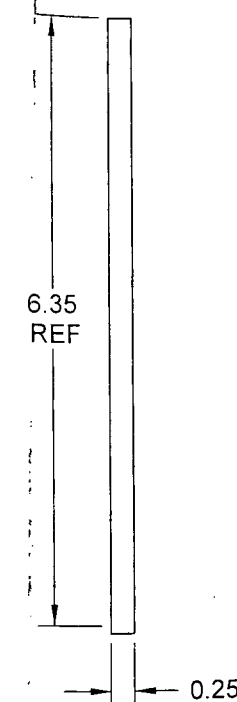
A



SUPPLEMENTAL VIEW



D3728-1 STEP BRACKET



DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	DE	D3728	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STEP BRACKET	1:2
DATE	08.02.22	COPY RIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

2 1

4 3